

Work Order ID 79088 -1

January-19-12 1:42:36 PM

79088

Page 1

Item ID: D3560-044

Revision ID:

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 4.00

Required Date: 02/02/2012 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: M L J

Date: 12/01/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

Cut blanks 15.500" long

0.00

Y.A 12/01/28

10 0

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

1- Mill as per Folio FA696 Rev: B & Dwg D3560 Rev: D
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

0.00

F.K 12/02/01

10

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

F.K 12/02/01

10

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Page 2

Item ID: D3560-044

Revision ID:

Item Name: Arm Weldment

Accept

N9000040100Setup Start ***NS1***Stop ***NS2***

Start Date: 19/01/2012 Start Qty: 4.00

4

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

OK 12/02/01

10

Quality Control

140

140

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

12.02.07

1

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Page 3

Item ID: D3560-044

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 4.00

4

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

112 02 01 ①

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

1 0 02/02/07

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

112 02/02/07 ①

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Page 4

Item ID: D3560-044

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

190

Small Fab

0.00

190

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

EP 2/02/07 ①

EP 2/02/07 ①

12 02 57 ①

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Page 5

Item ID: D3560-044

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm Weldment

Stop ***NS2***

Start Date: 19/01/2012 Start Qty: 4.00

4

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

Identify as per dwg & Stock Location: *WA*

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

12-02-07 1 0

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

M.L.J 12/02/07

12-02-07 ①

Picklist Print

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Page 1

Work Order ID: 79088

79088

Parent Item: D3560-044

D3560-044

Parent Item Name: Arm Weldment

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP Rev B ECN 987 07.10.09 EC verified by DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured No

100 Each 22.0000 1 4

D2808

Bushing

**

12/02/07

Location

Loc Qty

Loc Code

GA

22

32896

2

71879

8

76188

12

M6061T6B0.500X05.00
0

Purchased No

140 f 59.7480 1.295

5.452632

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

B.A 12/01/28

Location

Loc Qty

Loc Code

MAT001

35.748

112154

6.935

117933

4.813

119324

24

MAT004

24

120243

24

→ 120421

12.9583 ft

Picklist Print

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Page 2

Work Order ID: 79088

Parent Item: D3560-044

Parent Item Name: Arm Weldment

79088

D3560-044

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3592-1

Manufactured

No

190

Each

15.0000

1

4

D3592-1

Plate

**

12.02.07

Location

Loc Qty

Loc Code

WA

6

78934

6

WA002

9

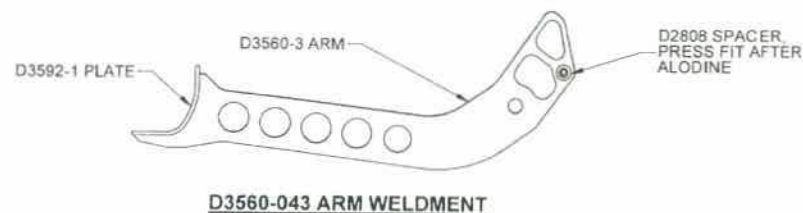
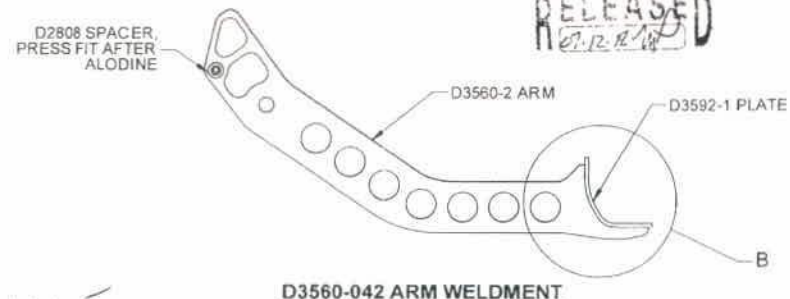
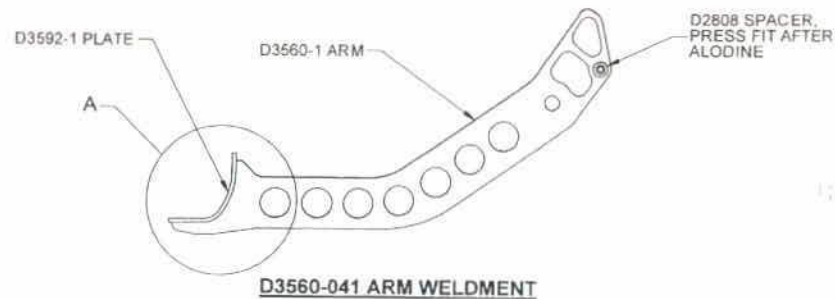
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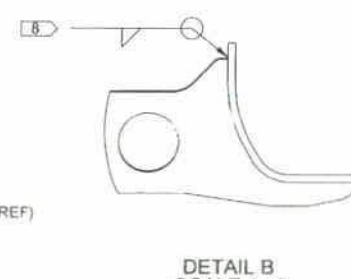
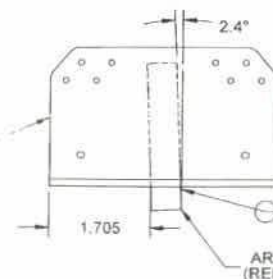
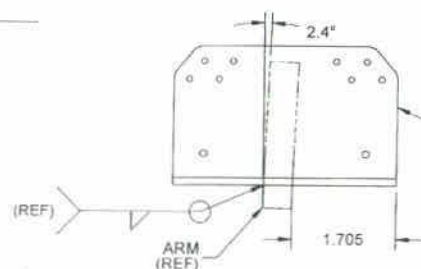
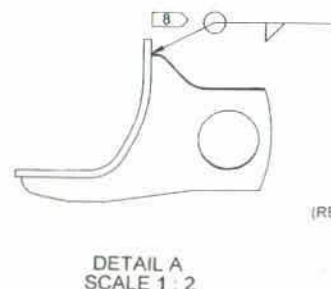
48517

7

RELEASED



79088 M.L.J
12/01/19



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

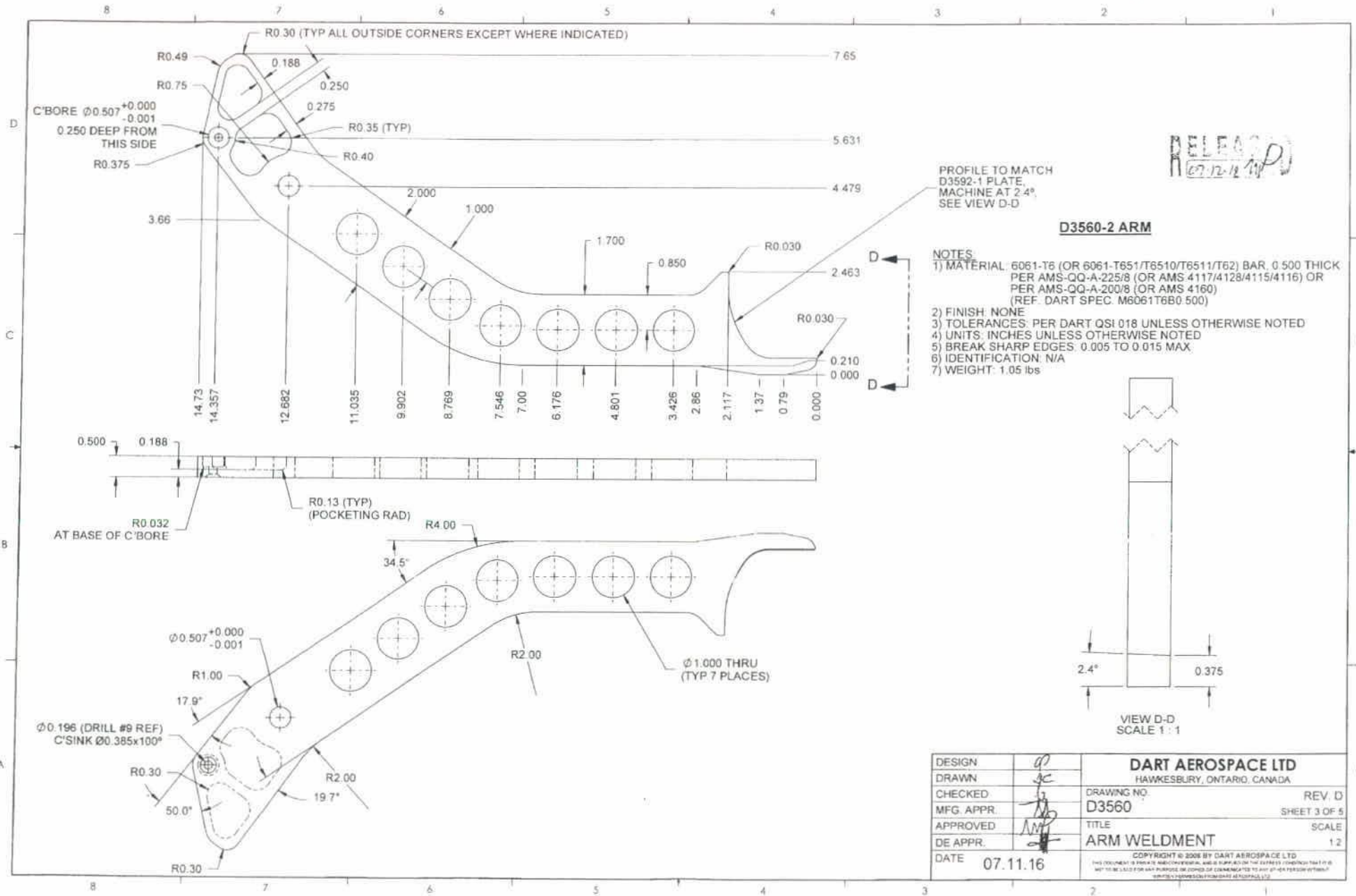
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3560
REV. D
SHEET 1 OF 5
SCALE 1:4

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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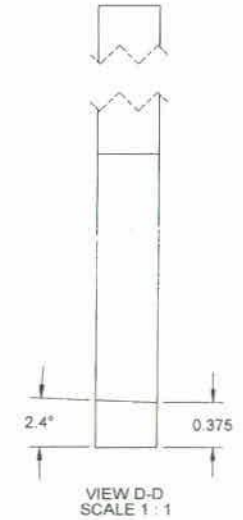
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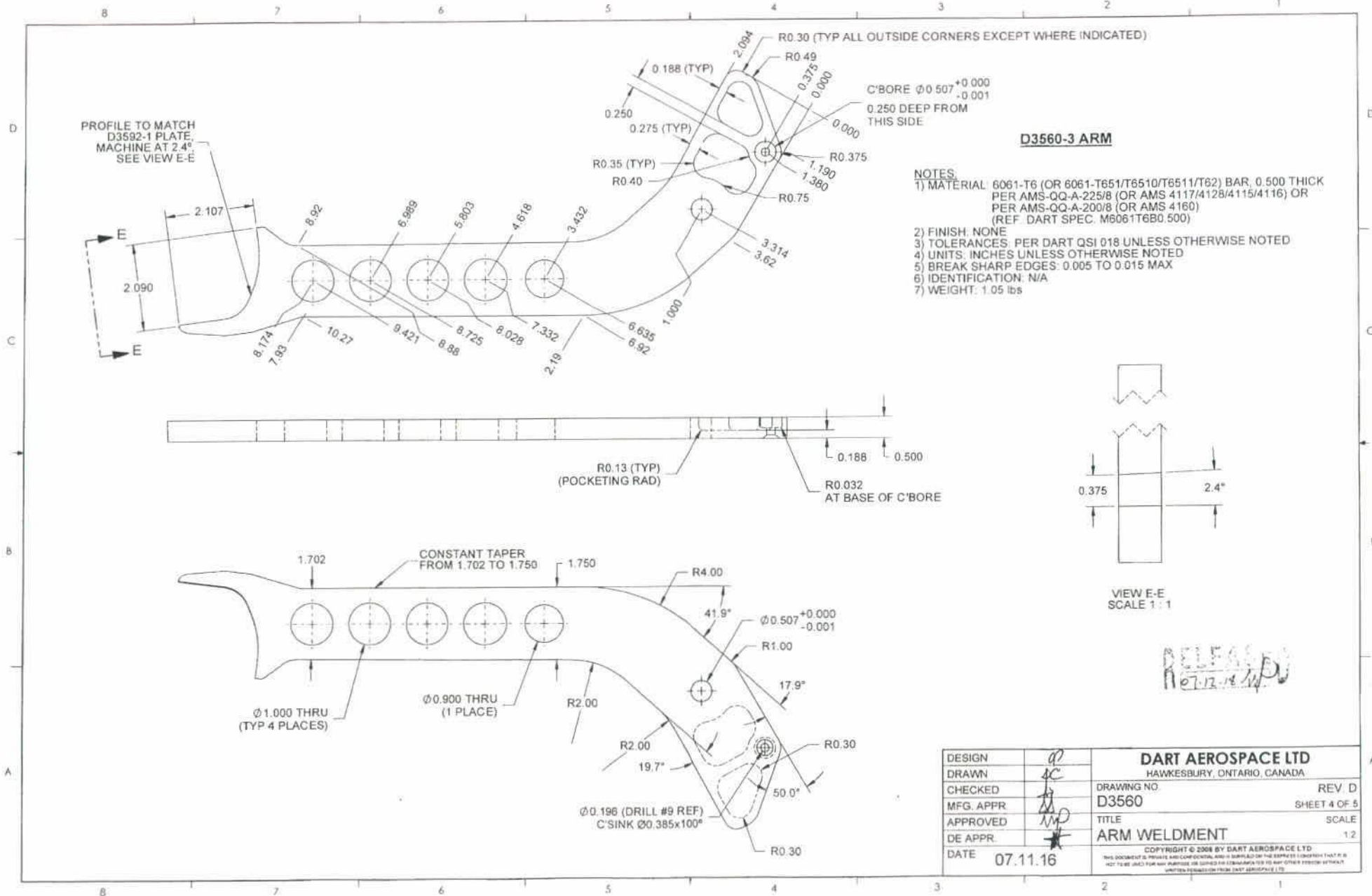
D3560-2 ARM

- NOTES**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX.
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

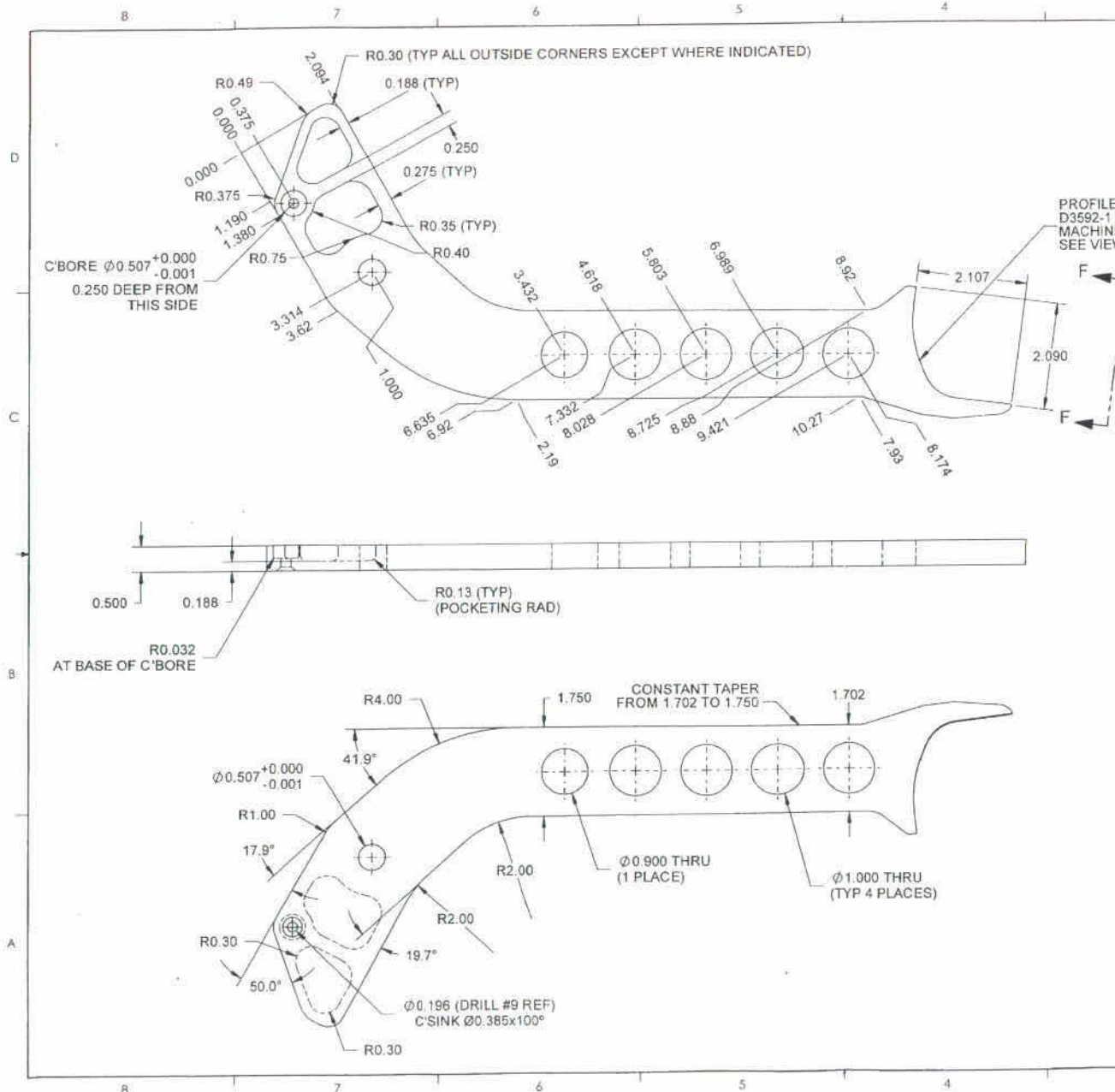


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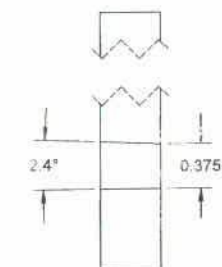
79088



PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW F-F

D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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